

Work Order ID 140323-2 *SPLIT-2* *140323*

Item ID: D5271-3 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: LH Aft Fitting
Start Date: 12/21/2015 Start Qty: 20.00 *20* 6
Required Date: 12/21/2015 Req'd Qty: 20.00 *20* 6
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: *[Signature]* Date: 12-23 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5271	A								

100
100 BAND SAW 0.00
Bandsaw Memo 0.03
Jeaspa Bandsaw Cut Blank at 8.00"
20 *φ* *SL 16-1-26*

110
110 HAAS CNC VERTICAL MACHINING #1 0.00
HAAS 5 AXIS Memo 0.17
HAAS CNC vertical machine #5
1-Machine per folio FB410
DWG REV: *A*
FOLIO REV: *AA*
2- deburr and break all sharp edges
18/02/10 *7* *φ* *DAS 08 9-89*

PTO
last page
Encl. attached

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER: _____																	

Work Order ID 140323

Monday, December 21, 2015 11:53:57 AM

140323

Page 2

Item ID: D5271-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: LH Aft Fitting
 Start Date: 12/21/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/21/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		B- 16/02/10		7	0		DAS 08 9-89
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				7	0		DAS 14 9-89 16/06/17
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O: <u>32760</u> Black Anodize as per Dwg D5271	0.00 24.00				7		JUN 20 2016	DAS 13 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 140323

Monday, December 21, 2015 11:53:57 AM

140323

Page 3

Item ID: D5271-3 Accept *N900040100* Setup Start *NS1*
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.01							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.01							
Quality Control									
180	Identify as per dwg & Stock Location: <i>St207</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

7x 8016-711

7

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JUL 14 2016

7

DAS
6
9-89

111 15 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
		OTHER : _____									

Work Order ID 140323

Monday, December 21, 2015 11:53:57 AM

140323

Page 4

Item ID: D5271-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: LH Aft Fitting
 Start Date: 12/21/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/21/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190 QC	Memo	0.03							
Quality Control									

DAS
21 JUL 1 5 2016
9-89

DAS
21 JUL 1 5 2016
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
10/2/2010 10/2/2010 10/2/2010								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Monday, December 21, 2015 11:53:57 AM

Page 1

Work Order ID: 140323

140323

Parent Item: D5271-3

D5271-3

Parent Item Name: LH Aft Fitting

Start Date: 12/21/2015

Required Date: 12/21/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP rev a RQ 15.09.10 Verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B3.500X03.50 0		Purchased	No			100	f	10.7000	0.666	14.02105			

M6061T6B3 500X03 500

6061-T6 Bar 3.5" x 3.5"

**

SL 16-1-26

Location

Loc Qty

Loc Code

MAT

10.7

→ m133121

10.7

→ m134067

→ 5.4

→ 8.6667 ft

DQA: _____ Date: _____

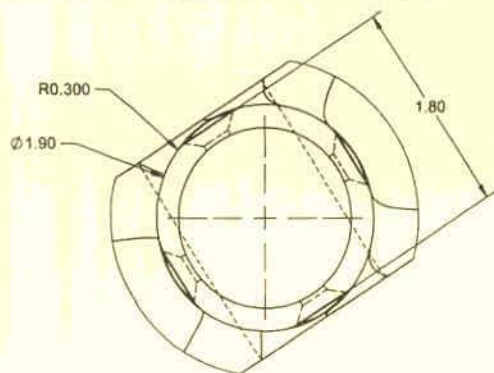


WORK ORDER NON-CONFORMANCE / UPDATE

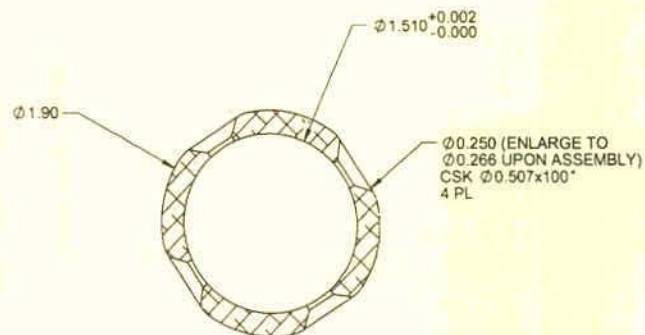
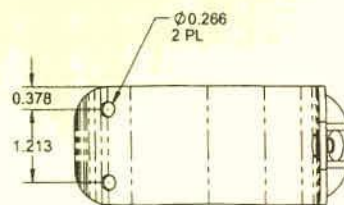
QA Closed: _____ Date: _____

Work Order update only ☐

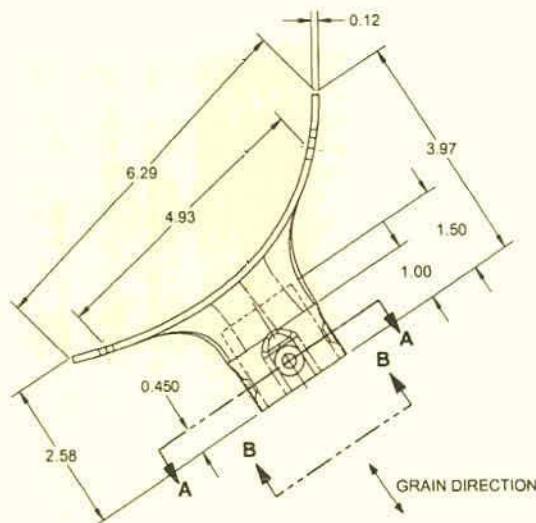
Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐	☐	Skid-tube ☐	☐	Cross tube ☐	☐	Water Jet ☐	Engineering ☐
NCR No. _____		Scrap ☐	☐	Machining ☐	☐	Small Fab ☐	☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐	☐	Thermoforming ☐	☐	Finishing ☐	☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐	☐	Large Fab ☐	☐	Composite ☐	☐	Supplier ☐	
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							



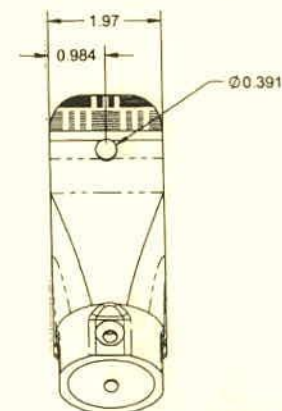
VIEW B-B



SECTION A-A



D5271-1 FORWARD FITTING



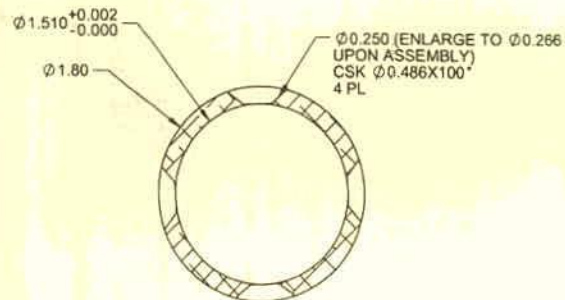
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T68
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER MACHINING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5271-1" PER DART QSI 044 SECTION 6.1
- 7) WEIGHT: 0.50 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5271-1REV. A.SLDPRT"

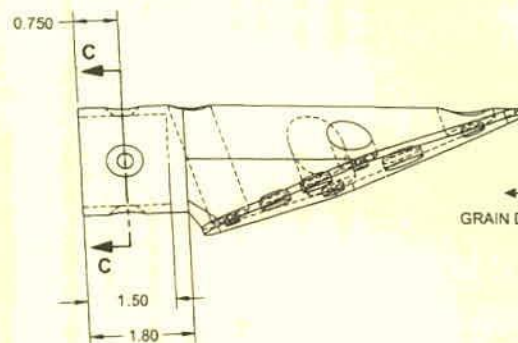
15-1223
140323

RELEASED
2015-12-07
ELN 15-649

A		ISSUE	CC	15.06.15
REV	DESCRIPTION		BY	DATE
DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA		
DRAWN	CC			
CHECKED	VS	DRAWING NO.	REV. A	
MFG. APPR.	JLM	D5271	SHEET 1 OF 3	
APPROVED	HS	TITLE	SCALE	
DE APPR.	DS	AIRCRAFT FITTINGS	NTS	
DATE	15.06.15		COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED, COPIED, REPRODUCED, OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

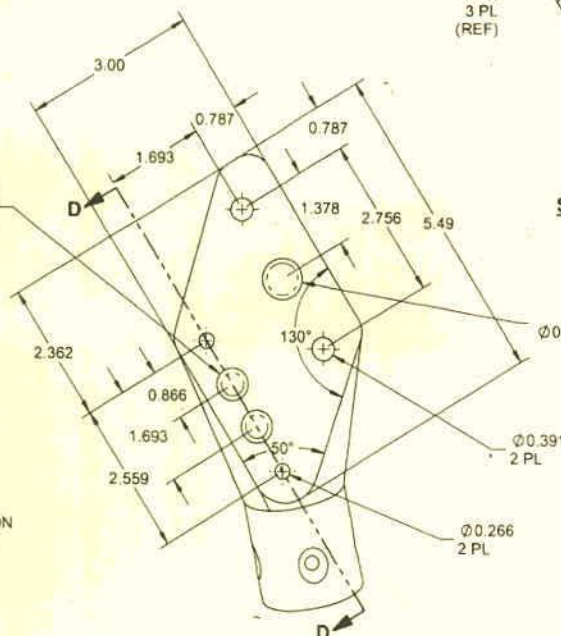


SECTION C-C



C'BORE
0.551 X 0.20 DEEP
2 PL

GRAIN DIRECTION



SECTION D-D

C'BORE
0.709 X 0.20 DEEP
2 PL

0.70
2 PL

0.90
2 PL

D5271-3 LH AFT FITTING

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINIUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER MACHINING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5271-3" PER DART QSI 044 SECTION 6.1
- 7) WEIGHT: 1.19 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5271-3REV: A.SLDPRT"

RELEASED
2015-12-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC	
DRAWN	CC	EUGENE, OREGON, USA	
CHECKED	VS	DRAWING NO	REV. A
MFG APPR	JLM	D5271	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR	DS	AIRCRAFT FITTINGS	NTS
DATE	15.06.15	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Jean-Luc Menard

From: Colin Corbett
Sent: Tuesday, June 14, 2016 9:15 AM
To: Jean-Luc Menard
Subject: RE: D5271

Hi JL,

Per our phone conversation, let's go with option 2. It does not matter if the counter bores are slightly oval.

Thanks!

Colin Corbett, P. Eng
Design Engineer

DART AEROSPACE
T 1 403 717-0328 > 428



From: Jean-Luc Menard
Sent: 10-Jun-16 07:28
To: Colin Corbett <CCorbett@dartaero.com>
Cc: Guillaume Auclair <gauclair@dartaero.com>
Subject: D5271

Hi Colin,

We ran into a little problem re-working the parts to add the c-bores ,7 parts affected.
See attached for the sketch with dim affected,only the counter bores are affected,the mounting holes are as per dwg.
We have two options:

1-leave as is if acceptable.

2- re run the counterbores and bring them to max tol (~~+0.30~~), the holes will be a little oval.

Let me know if you have any questions,
JL

Jean-Luc Menard
Production Engineering Supervisor

DART AEROSPACE
T 1 613 632-5200 > 227
F 1 613 632-5246
1 800 556- 4166
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO32760

Purchase Order Date 6/20/2016

PO Print Date 6/27/2016

Page Number 3 of 7

Order From: VC-ATG001

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ROCKLAND, ON K4K 1T2
CANADA

Ship To: DART AEROSPACE LTD

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HAWKE
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ON
K6A
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Contact Name

Vendor Phone 613-446-4544

Vendor Fax 613-446-4556

Ship To Contact

Ship To Phone

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

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Currency

CAD

FOB

FCA - (Free Carrier)

Ship Method

VENDOR'S TRUCK

Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
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9 140323 ✓ D5271-3 AFT FITTING 7/8/2016 7.00 ✓
REV A Yes

7/8/2016

BLACK ANODIZE PER MIL-A-8625F TYPE I ,IB,IC,II OR IIB, CLASS 2

Line Total:

\$40.25

10 145628 ✓ D5271-1 FOWARD FITTING REV. A 7/8/2016 6.00 ✓
Yes

7/8/2016

BLACK ANODIZE PER MIL-A-8625F TYPE I ,IB,IC,II OR IIB, CLASS 2

Line Total:

\$36.00

6/27/2016



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Date: 08-Jul-16

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1270 Aberdeen St
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CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

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Quantity	Description		
6 ea	Part: 145628 D5271-1 Forward fitting Job: 19708	PO: 32760	Rev: Line: 10
4 ea	Part: 146831 D5273-043 End fitting Job: 19710	PO: 32760	Rev: B Line: 14
8 ea	Part: 147746 D5273-3-041 End fitting Job: 19711	PO: 32760	Rev: B Line: 15
1 ea	Part: 71401-45 Administration fee Job: 19713	PO: 32760	Rev: N/A Line: 18
16 ea	Part: 141006 646.3012 Lower Guide Job: 19700	PO: 32760	Rev: N/C Line: 5
6 ea	Part: 146954 D5230-3 Mounting plate Job: 19706	PO: 32760	Rev: A Line: 8
7 ea	Part: 145628 D5271-3 AFT fitting Job: 19707	PO: 32760	Rev: A Line: 9
DATE: 8/7/16 CERTIFIED SIGNATURE: <i>[Signature]</i>			



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